

**Work Order ID 69338**

Monday, May 09, 2011 11:29:35 AM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*R*

Date: 11-05-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

*Sulozky**for BG 11-8-18*

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *141039*  
Description: D2445 Baggage Door  
Supplier: Delastek  
Ship to Delastek (1) D0588-041 label  
Certification of Conformity and process sheet from Delastek is required.

*pl 11-05-9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69338**

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Page 2

Item ID: D350-588-041

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Setup Start

Revision ID:

Stop

Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

• Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69338**

Monday, May 09, 2011 11:29:35 AM



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Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Sp 08-11-26

PHO →

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O: 69338


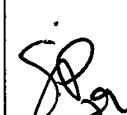
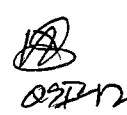
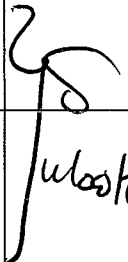
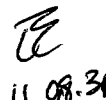
## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D80-588-041 PAR #: N/A Fault Category: Production Eng. Coord. NCR: Yes No DQA: ✓ Date: 11.08.31  
 Resolution: Re work Disposition: Re work QA: N/C Closed: ✓ Date: 11/08/31

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
W/O: 69338	#100	Missing from w/o Pick list was A19603D8 washer. R.C. w/o not created correctly		→ ADD A19603D8 QTY 16 in M117316 to kit NAS442018825	 11.08.31	S W/O: 69338		
				→ Correctly update w/o + Bom. ADD copy of update Bom for Ref.	 11.08.31			

NOTE: Date &amp; initial all entries

**Work Order ID 69338**

Monday, May 09, 2011 11:29:35 AM

Page 4

Item ID: D350-588-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29

11/8/29

MF 11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, May 09, 2011 11:29:48 AM

Page 1

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly






Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04 Reformat KJ/DS IPP Rev:Q as  
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD  
10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149DN832J  WASHER		Purchased	No				Each	1,358.000		24			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST297		1358							
				117316		1358							
D2445P  AFT DOOR ASSEMBLY		Purchased	No			110	Each	0.0000	1	1			
AN526C832R9  Screw		Purchased	No			140	Each	603.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		603							
				117010		7							
				117619		196							
				117628		400							
AN960JD10  Washer	NAS1149D0363J	Purchased	No			140	Each	0.0000	2	2			
D2143  Hinge Bracket		Manufactured	No			140	Each	31.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST198		31							
				64308		31							

25 11-08-17

x24

25 11-08-17

25 11-08-17

x8

25 11-08-17

25 11-08-17

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 09, 2011 11:29:49 AM

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2144 Manufactured No 140 Each 20.0000 1 1



Hinge Bracket



11-08-17

Location

Loc Qty

Loc Code

ST198

20

64778

20

X1

D2463 Manufactured No 140 f 555.0600 7.25 7.25



Seal



11-08-17

Location

Loc Qty

Loc Code

ST404

555.06

64944

62.66

66954

492.4

X7.25

(D2463-0870) cut (1) at 87.00"  
\*\*\*\* per kit\*\*\*

D2585 Manufactured No 140 Each 41.0000 2 2



Mounting Channel



11-08-17

70814

Location

Loc Qty

Loc Code

ST017

41

66142

41

D2586 Manufactured No 140 Each 107.0000 2 2



Door Latch



11-08-17

Location

Loc Qty

Loc Code

ST204

107

64656

7

64774

100

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, May 09, 2011 11:29:49 AM

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2621 Manufactured No 140 Each 42.0000 2 2  
  
 Latch Plate, 350 Spacepod



BT 11-08-17

Location Loc Qty Loc Code

ST019 42  
 56526 42

D2857-1 Manufactured No 140 Each 1.0000 1 1  
  
 Hinge Bracket



X2

BT 11-08-17

Location Loc Qty Loc Code

ST024 1  
 64435 1

D2857-2 Manufactured No 140 Each 21.0000 1 1  
  
 Hinge Bracket



BT 11-08-17

Location Loc Qty Loc Code

ST024 21  
 64463 11  
 65091 10

MS21042L08 Purchased No 140 Each 303.0000 8 8  
  
 Nut



X1

BT 11-08-17

Location Loc Qty Loc Code

ST300 303  
 117087 6  
 117441 97  
 117601 200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Monday, May 09, 2011 11:29:49 AM

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

140 Each

2,400.000

2 2



Nut



25 11-06-17

## Location

## Loc Qty

## Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

25

MS27039-1-15 Purchased No

140 Each

100.0000

2 2



Screw



25 11-08-17

## Location

## Loc Qty

## Loc Code

ST292

100

116916

100

155 Each

76.0000

2 2

AN526C1032R7

Purchased

No



Screw



25 11-08-26

## Location

## Loc Qty

## Loc Code

MEZZ

2

113064

1

113749

1

ST328

74

116304

74

155 Each

33.0000

8 8

AN526C832R8

Purchased

No



Screw



25 11-08-26

## Location

## Loc Qty

## Loc Code

ST327

33

116471

33

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Shop Packet Print

Page 4

B117688 4X  
B 117735 4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, May 09, 2011 11:29:50 AM

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Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No



Washer

D2150



Packer Doubler, Hinge

Manufactured No

140  
155 155 Each 0.0000  
~~118077~~ 118077  
155 Each 9.0000

2 2 SP 11-08-27  
~~11-08-17~~

2 2 SP 11-08-26  
B69514

Location Loc Qty Loc Code

ST006 9

D2151



Packer Doubler, Hinge

Manufactured No

64764  
~~B69514~~ 2X  
155 Each 17.0000

2 2 SP 11-08-26

Location Loc Qty Loc Code

ST006 17

D2153



Door Prop

Manufactured No

64776  
~~B69515~~ 1X  
155 Each 26.0000

1 1 SP 11-08-26

Location Loc Qty Loc Code

ST272 26

D2154



Stud Bracket

Manufactured No

64943  
155 Each 34.0000

1X  
1 SP 11-08-26

Location Loc Qty Loc Code

ST006 34

64312 34

1X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

Monday, May 09, 2011 11:29:50 AM

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2237

Manufactured No

155

Each

66.0000



Striker Plate

Location

Loc Qty

Loc Code

ST009

66

64762

2

66139

64

2 2  
SP 8P 11-08-26  
B705581X

D2461

Manufactured No

155

f

196.5000



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

196.5

39782

6.5

55054

4

63880

186

7.25 7.25  
SP 8P 11-08-26

(D2461-0870) cut (1) at 87.00"  
\*\*\*\* per kit\*\*\*\*

D2589

Manufactured No

155

Each

110.0000



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

110

58194

110

SP 8P 11-08-26

D2690-17

Manufactured No

155

Each

22.0000



Cable

Location

Loc Qty

Loc Code

ST020

22

64786

1

66510

21

1 1'  
SP 8P 11-08-26  
IK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Monday, May 09, 2011 11:29:50 AM

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2858-1 Manufactured No

155 Each

11.0000

1



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64785

11

155 Each

11.0000

1

D2858-2

Manufactured No



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64787

11

155 sf

2,673.970

1

FG-778150-550-ROL

Purchased

No



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

CA

1649.97

117602

1649.97

ST404

1024

104845

3

108932

18

111166

392

113905

611

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No



RIVET

Location

Loc Qty

Loc Code

ST316

5258

104374

1258

110398

4000

155 Each

5,258.000

12



SP 11-08-26  
B69595

SP 11-08-26  
B69594 1X

SP 11-08-26  
08-11-26

1X

12 11-08-26  
SP 08-11-26

12X

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Monday, May 09, 2011 11:29:51 AM

Work Order ID: 69338

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

155

Each

1,533.000

18

18



Rivet, Universal Head



SP SP 11-08-26.

## Location

## Loc Qty

## Loc Code

ST319

1533

116410

14

116893

1519

18x

MS21042L08

Purchased

No

155

Each

303.0000

10

10



Nut



SP SP 11-08-26.  
M118242 10x

## Location

## Loc Qty

## Loc Code

ST300

303

117087

6

117441

97

117601

200

MS21042L3

Purchased

No

155

Each

2,400.000

4

4



Nut



SP SP 11-08-26

## Location

## Loc Qty

## Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

4x

MS27039-08-11

Purchased

No

155

Each

183.0000

2

2



Screw



SP SP 11-08-26.

## Location

## Loc Qty

## Loc Code

ST290

183

116289

33

117441

150

2x

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Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

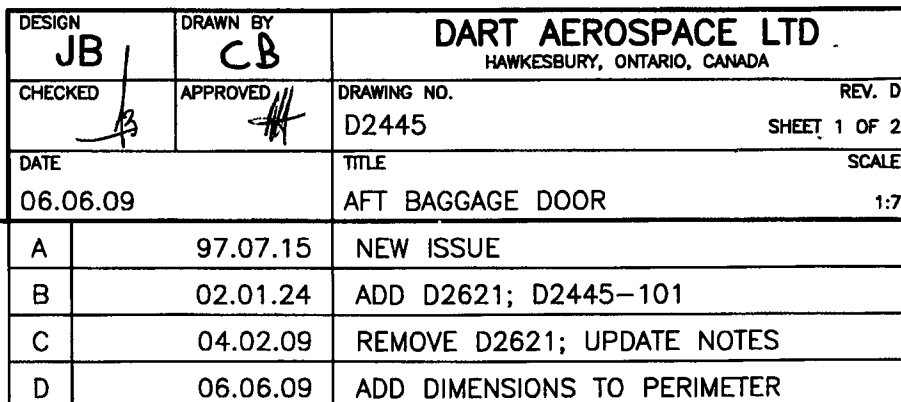
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

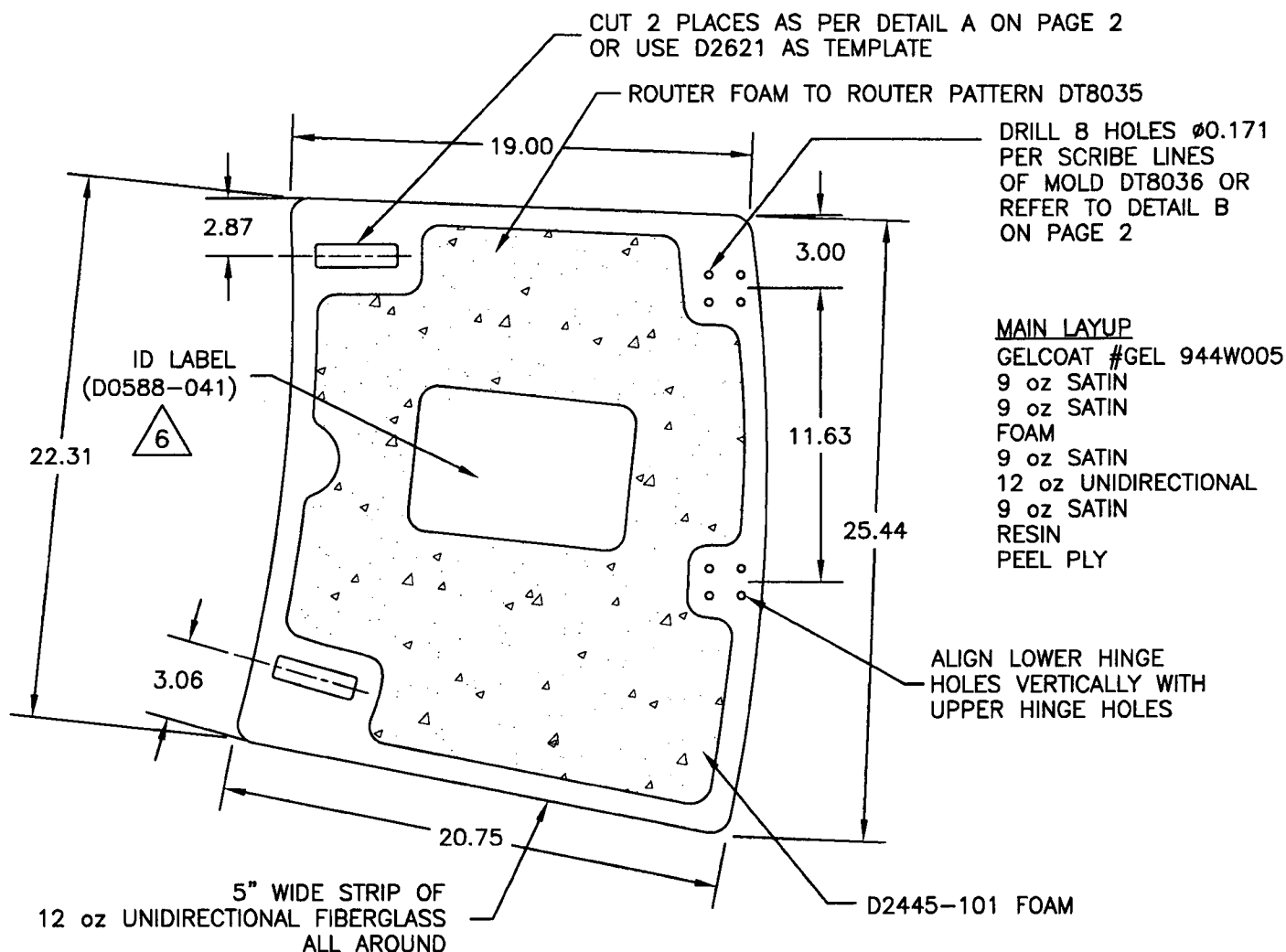
**NOTE:** Date & initial all entries





RELEASED

pl. 11.13



**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMNYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

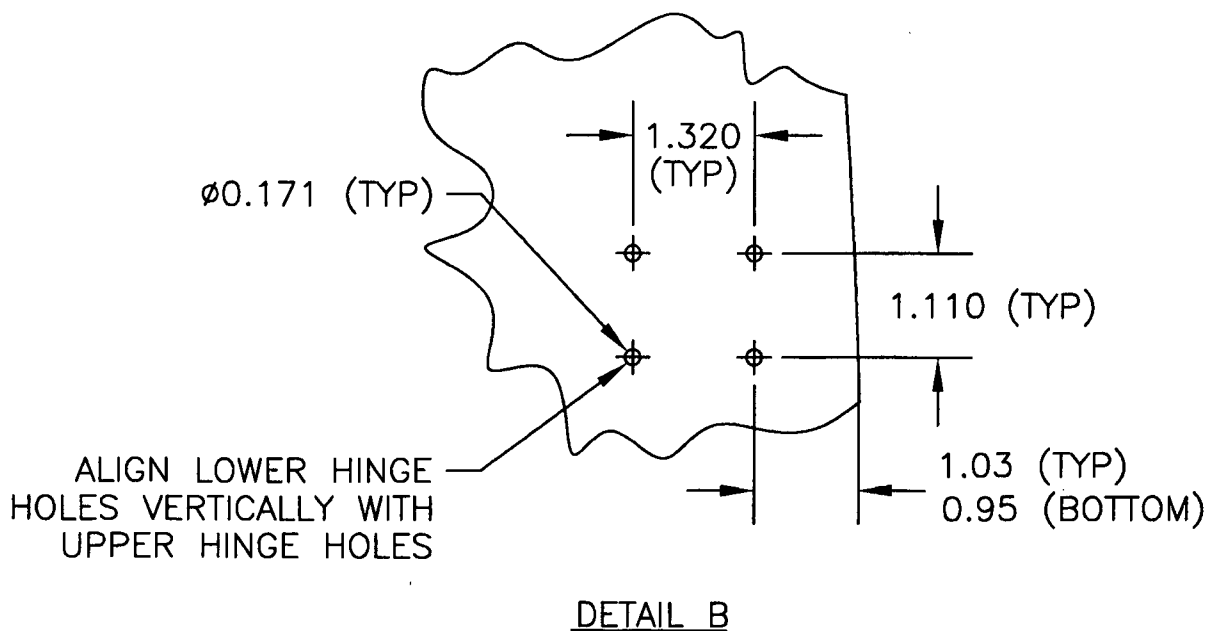
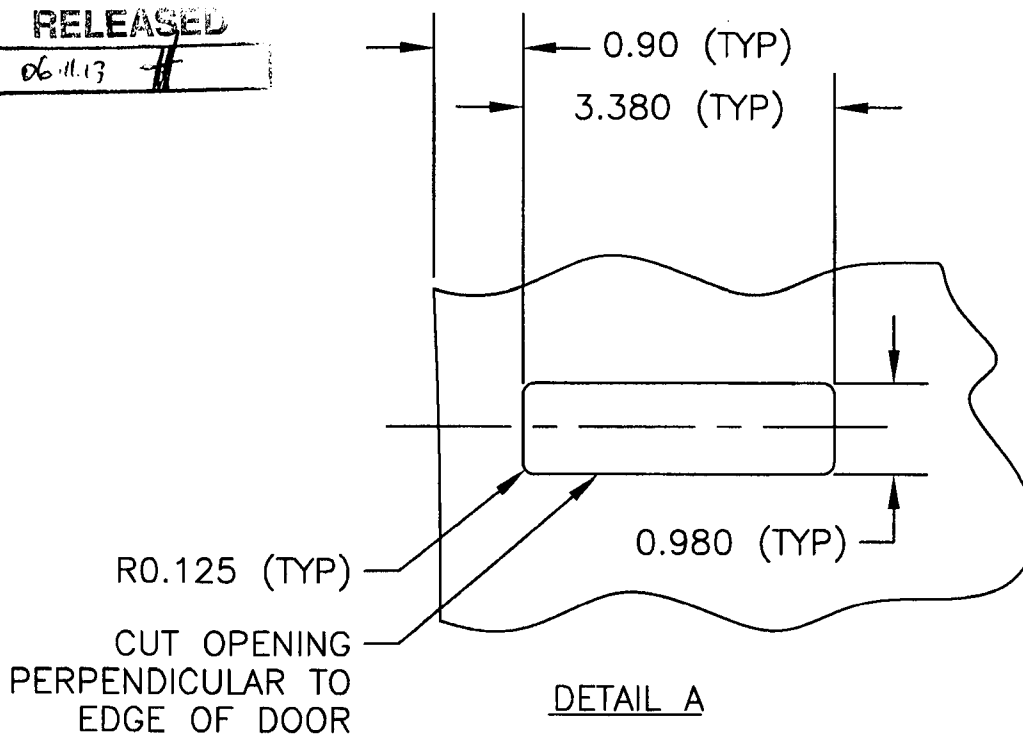
**NOTE:** Date & initial all entries

**DART**

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED

06.11.13



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	39530
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

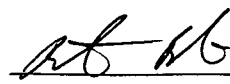

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Point de départ		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
22/07/2011	09/05/2011	17521	Brigitte Golden	14039			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	Line 4 D350-588-041 Aft Baggage Door (D2445) B69338 U de M : Each Drawing N° : D2445 Rév.: D  <u>No. série</u> B69338  <u>No. lot</u> 33208			

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:   
Quality department        AQ-357

Date: Lundi, 2011-05-09 17:47:38  
 Utilisateur: Pascal Carignan

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 33208	Numéro Article	: DKC134-0013
Numéro Soumission	: 3959	Numéro Dessin	: D2445
Numéro B.A.	: Kit 854	Projet Numéro	: DK-134
Cette fois	: 2011-05-09 No. B.V. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - - Type :	Date Due	: 2011-05-16
Job précédente	: 33207	Qté:	1 Udm: UNITE
Écrit par	: _____		
Vérifié & Approuvé par	: _____		
Commentaires	: N° de pièce Client: D2445		

B69338

Process Sheet Rév.: 01 changer le sikkens AAC1390 pour le P15-3  
 (AAC1492), enlever le AAC1617, changer le freekote 44-NC pour le  
 Wolo

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)  
 N° 83634, Frekote Loctite Wolo # de Lot: 1-28909-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009.

Date: 6/07/11 Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)  
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-31135-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)  
 Catalyst N° DDM-9 N° de Lot: 1-28909-1

5.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 6/07/11 Sceau:



Date: Lundi, 2011-05-09 17:47:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 33208

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 6/07/11 Sceau:



7.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

8.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

9.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-31000-2

12.0	AMB0349	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Lundi, 2011-05-09 17:47:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 33208

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description:

Date: 06 juillet 11 Sceau:

15.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31288-1

17.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 7/07/11 Sceau:

18.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 7/07/11 Sceau:



19.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 12:35 Heure Curing Fin: 8:00 le 8/07/11

Date: 7/07/11 Sceau:





Date: Lundi, 2011-05-09 17:47:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 33208

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

20.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31288-1

22.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 22/06/11 Sceau:

23.0 AAC1611 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)  
Polybond B46F N° de Lot: 1-27795-1

24.0 DKC134-0029 Foam Core N° D2445-101 ( Pour AFT Baggage Door )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Foam Core N° D2445-101 ( Pour AFT Baggage Door ) N° de Job: 33663

25.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 11 juillet 11 Sceau:

26.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 8:30 Heure Fin Curing: 9:30

Date: 11/07/11 Sceau:

Date: Lundi, 2011-05-09 17:47:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 33208

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

27.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31288-1

29.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 12/07/11 Sceau:



30.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 12/07/11 Sceau:



31.0	BAGGING	Faire le bagging sur la pièce
------	---------	-------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 10:45 Heure Curing Fin: 7.30

Date: 12/07/11 Sceau:



13 juillet 11

Date: Lundi, 2011-05-09 17:47:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 33208

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

32.0	DÉMOULAGE	Démoulage de la pièce
------	-----------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Date: 13 juillet 11 Sceau:



33.0	TRIMAGE	Trimage
------	---------	---------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 13 juillet 11 Sceau:



34.0	AAC1605	Label N° D0588-041
------	---------	--------------------

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Label N° D0588-041 N° de Lot: 1-31017-1

35.0	AAC1609	Surface Veil
------	---------	--------------

Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)  
Surface Veil N° de Lot: N/A

36.0	AAC220	Résine Mia-Poxy 100
------	--------	---------------------

Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)  
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

37.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy
------	---------	------------------------------------

Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-26296-2

38.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: 18/07/11 Sceau:



## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 33208

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

39.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

# de Lot:

1-31178-3

40.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date:

19/07/11

Sceau:



41.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot:

1-30270-1 Bâtisseur

42.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot:

1-29932-3 Bâtisseur

43.0 PRIMER Application primer



①



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Date:

20 juillet 11

Sceau:



# de fiche de mélange:

N/A fine

Bâtisseur

44.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date:

21 JUL. 2011

Sceau:



RDP

45.0 EMBALLAGE Emballage &amp; Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057.

Date:

22 JUL 11

Sceau:



QTE: 1

REFERENCE ONLY

## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
<del>1</del>	<del>1</del>	<del>D2143</del>	<del>HINGE DOUBLER</del>
<del>1</del>	<del>1</del>	<del>D2144</del>	<del>HINGE DOUBLER</del>
<del>2</del>	<del>2</del>	<del>D2150</del>	<del>HINGE PACKER</del>
<del>2</del>	<del>2</del>	<del>D2151</del>	<del>HINGE DOUBLER</del>
<del>1</del>	<del>1</del>	<del>D2153-3315-10</del>	<del>GAS SPRING ASSY.</del>
<del>1</del>	<del>1</del>	<del>D2154</del>	<del>STUD BRACKET</del>
<del>2</del>	<del>2</del>	<del>D2237</del>	<del>STRIKER PLATE</del>
<del>1</del>	<del>1</del>	<del>D2445</del>	<del>DOOR</del>
<del>1</del>	<del>1</del>	<del>D2461-0870</del>	<del>NEOPRENE D SEAL</del>
<del>1</del>	<del>1</del>	<del>D2463-0870</del>	<del>1/2" FOAM SEAL</del>
	2	D2583	LATCH BRACKET
<del>2</del>	<del>2</del>	<del>D2585</del>	<del>LATCH CLAMP</del>
<del>2</del>	<del>2</del>	<del>D2586</del>	<del>LATCH</del>
	1	D2587	PLUG
<del>1</del>	<del>1</del>	<del>D2589</del>	<del>KEYS, KEY CHAIN</del>
<del>2</del>	<del>2</del>	<del>D2621</del>	<del>LATCH PLATE</del>
<del>1</del>	<del>1</del>	<del>D2690-17</del>	<del>CABLE, DOOR STOP</del>
<del>1</del>	<del>1</del>	<del>D2857-1</del>	<del>LOWER HINGE BRACKET</del>
<del>1</del>	<del>1</del>	<del>D2857-2</del>	<del>UPPER HINGE BRACKET</del>
<del>1</del>	<del>1</del>	<del>D2858-1</del>	<del>LOWER HINGE BRACKET</del>
<del>1</del>	<del>1</del>	<del>D2858-2</del>	<del>UPPER HINGE BRACKET</del>
8	8	AN526C832R8	SCREW (or AN526-832R8)
<del>8</del>	<del>8</del>	<del>AN526C832R9</del>	<del>SCREW (or AN526-832R9)</del>
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
<del>4</del>	<del>4</del>	<del>AN960JD10</del>	<del>WASHER</del>
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
<del>4</del>	<del>4</del>	<del>MS21042L3</del>	<del>NUT (or MS21042-3) -2</del>
<del>2</del>	<del>2</del>	<del>MS27039-1-15</del>	<del>SCREW</del>
<del>2</del>	<del>2</del>	<del>MS27039-0811</del>	<del>SCREW</del>
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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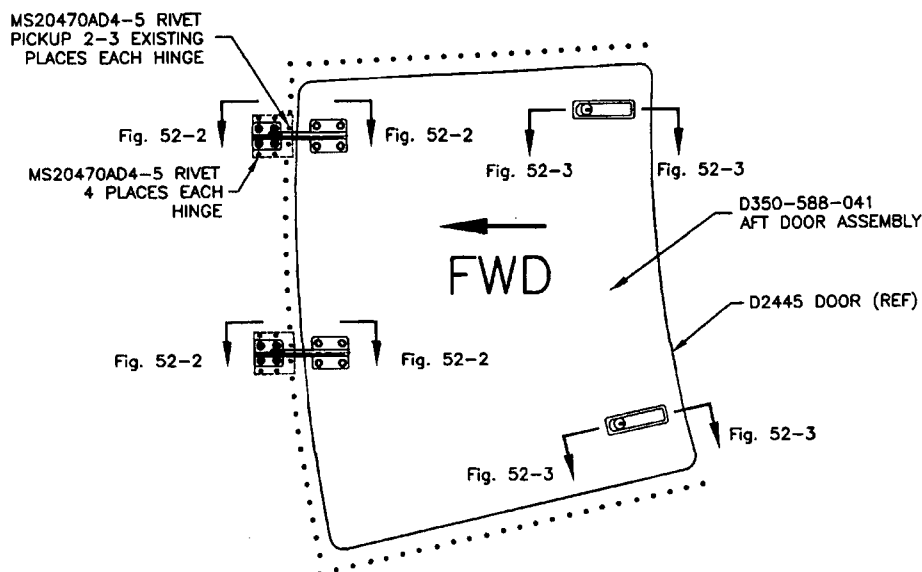


Figure 52-1: Baggage Door Outside View

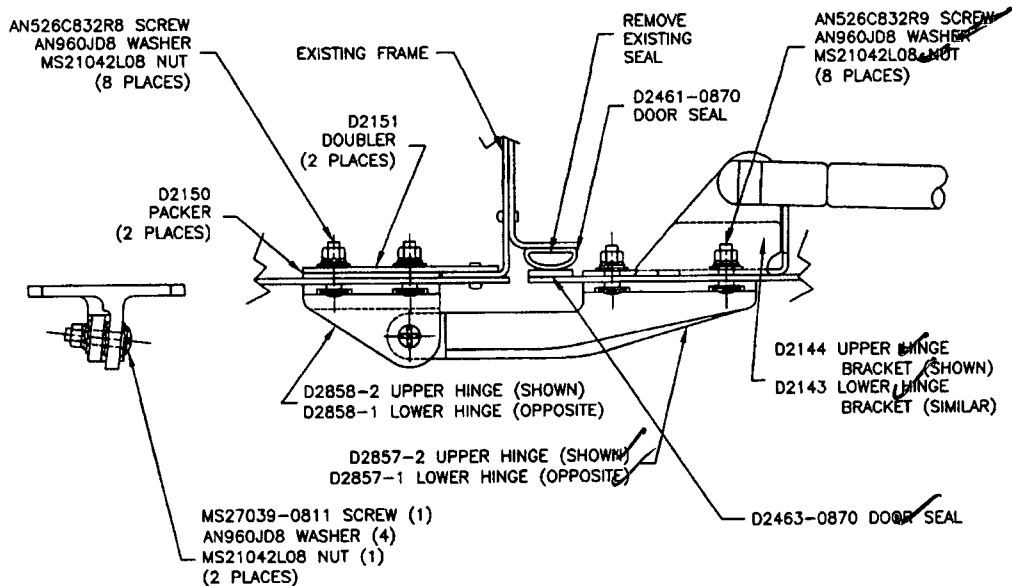
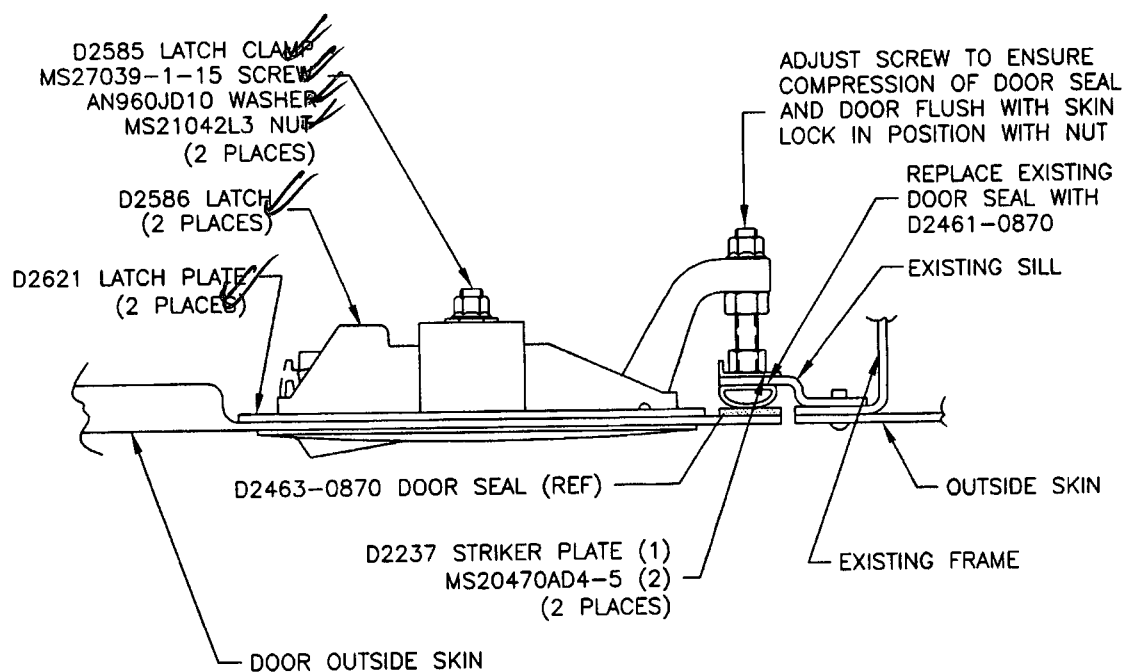


Figure 52-2: Hinge Detail

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**REFERENCE ONLY****Figure 52-3: Latch Section**

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